

Date: Tuesday, 4/18/2006 9:58:56 AM
 User: Kim Johnston

Process Sheet

Split 80 06/05/19

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : FOLDING STEP WELDMENT LH
 Job Number : 26652
 Estimate Number : 10463
 P.O. Number : *N/A*
 This Issue : 4/18/2006 S.O. No. : *N/A*
 Prsht Rev. : NC
 First Issue : *N/A* Type : LARGE FAB ASSY
 Previous Run : 26156
 Written By : *SEE COMMENT BELOW*
 Checked & Approved By : *06.04.18*
 Comment : Est. B 05.06.10 Added Step 11 KJ/JLM

Part Number : D3388041
 Drawing Number : D3388 REV A
 Project Number : N/A
 Drawing Revision : A
 Material : *N/A*
 Due Date : 5/10/2006 Qty: *2* Um: *5* Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D2622120C Extrusion



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)
 D2622-120C extrusion 8
 Batch: *324563*

SE 06.04.24 5

2.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1
 1-Cut D2622-120C extrusion 85.15" long as per Dwg D3388
 2-Deburr and bevel ends for welding

SE 06.04.24 5

3.0 D2734 206 Step Endplate



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)
 206 Step Endplate
 Pick:

Qty	Part Number	Description	Batch
2	D2734	End Cap	<i>324462</i>

SE 06.04.25 5

4.0 D33871 Arm



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Arm

Pick:

Qty	Part Number	Description	Batch
2	D3387-1	Arm	<i>325933=4</i>

326161=6 SE 06.04.25 5

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Job Number: 26652

Part Number: D3388041

Job Number:



Seq. #: Machine Or Operation: Description :

5.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld arms and end caps as per Dwg D3388.

Inspect for foreign objects as per QSI 024. Dwg Rev: A

Grind end cap welds flush

welding rod 3 m19173

06.04.25

5

06.04.27

5

6.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

SAD M.F.

06.05.04

2

06.05.02

3

5

7.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

g.m 06/05/11

5

8.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk as per Dwg D3388 and QSI 005 4.4

FC 06 05 12

9.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Inspect Powder Coat and Wing Walk

SB 06/05/19

10.0 D2808 Spacer



Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)

Spacer

Pick:

Qty	Part Number	Description	Batch
1	D2808	Spacer	<i>B:24648</i>

51

SB 06/05/19

2

11.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Press spacer into D3387-1 arm as per Dwg D3387

SAD 06.05.19

2

Process Sheet

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Drawing Name: FOLDING STEP WELDMENT LH

Job Number: 26652

Part Number: D3388041

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

14.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion



U 20.05.23

